

Date: Tuesday, 10/02/2009 11:09:20 AM
 User: Julie Dawson

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services Drawing Name : HINGE
 Job Number : 45674
 Estimate Number : 13568
 P.O. Number : Part Number : D38143
 This Issue : 10/02/2009 S.O. No. : Drawing Number : D3814 REV A
 Prsht Rev. : NC Project Number : N/A
 First Issue : / / Type : MACHINED PARTS Drawing Revision : A
 Previous Run : 43018 Material :
 Written By : Due Date : 28/02/2009 Qty: 6 Um: Each
 Checked & Approved By : JLD 09.02.10
 Comment : Est Rev:A New Issue 08-09-03 JLM Verified By:EC

Additional Product

Job Number:



Seq. #: Machine Or Operation: Description :

1.0 M6061T6B2000X03500 6061-T6 Bar 2.00 x 3.50



Comment: Qty.: 0.4150 f(s)/Unit Total : 0.8299 f(s)
 6061-T6 Bar 2.00" X 3.500"
 BATCH: M16391

JL 09/02/12

2.0 BAND SAW BAND SAW



Comment: BAND SAW
 Cut blank 4.75" " long

JL 09/02/12

3.0 HAAS1 HAAS CNC VERTICAL MACHINING #1



Comment: HAAS CNC VERTICAL MACHINING #1

1- Mill as per Folio FA780 Rev: AA & Dwg D3814 Rev: A

2-Deburr per dwg D3814

3-Finish tapping hole to final depth as per Dwg D3814

J.F. 09/02/12

4.0 QC2 INSPECT PARTS AS THEY COME OFF MACHINE



Comment: INSPECT PARTS AS THEY COME OFF MACHINE

J.F. 09/02/12

5.0 QC8 SECOND CHECK



Comment: SECOND CHECK


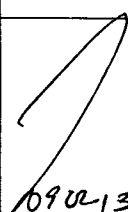
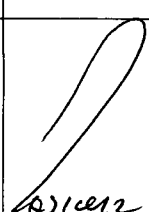

JP 09/02/12

⑥

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: D3814-3 PAR #: N/A Fault Category: Prod / Machine / PM NCR: (Yes) No DQA: ID Date: 09/02/25
 Resolution: D30-780-011 SCRAP Disposition: SCRAP QA: N/C Closed: ID Date: 09/02/25

NCR: 45674		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
09/02/12	3.0	1 part scrap. Machine did not pick-up the tool properly and took a chunk out of the side. R.c: Machine mal function.	 J.F.	Scrap & replace Qty 1	J.F. 09/02/12	 09/02/13	 09/02/12	 09/02/13

NOTE: Date & initial all entries

Date: Tuesday, 10/02/2009 11:09:20 AM
User: Julie Dawson

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: HINGE

Job Number: 45674

Part Number: D38143

Job Number:



Seq. #: Machine Or Operation: Description :

6.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Chemical Conversion Coat as per QSI 005 4.1

BF 09-02-17 (6)

7.0

POWDER COATING

POWDER COATING



Comment: POWDER COATING

Powder Coat White Gloss (Ref: 4.3.5.1) as per QSI 005 4.3

~~***MASK THREADED HOLE PRIOR TO POWDER COAT***~~

N/A 09-02-18

START TIME:

2:00pm

OVEN TEMPERATURE:

320°C

FINISH TIME:

2:30pm

JD 09-02-18 (6)

8.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

FL 09/02/18 (6)

9.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location:

Peg/4 19 (6)

10.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

09/02/20 (6)

Job Completion



MF 09-02-19

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART AEROSPACE LTD		Work Order: 45674
Description: Hinge		Part Number: 03814-3
Inspection Dwg: 03814 Rev: A		Page 1 of 2

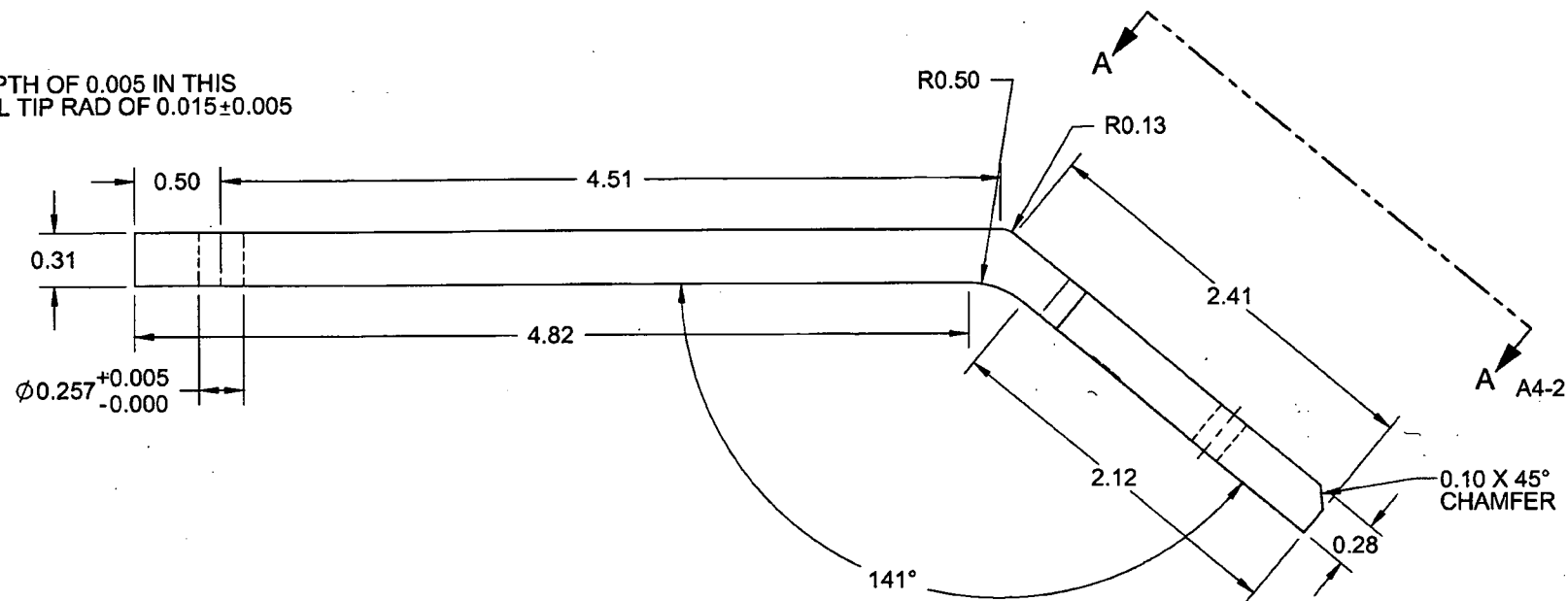
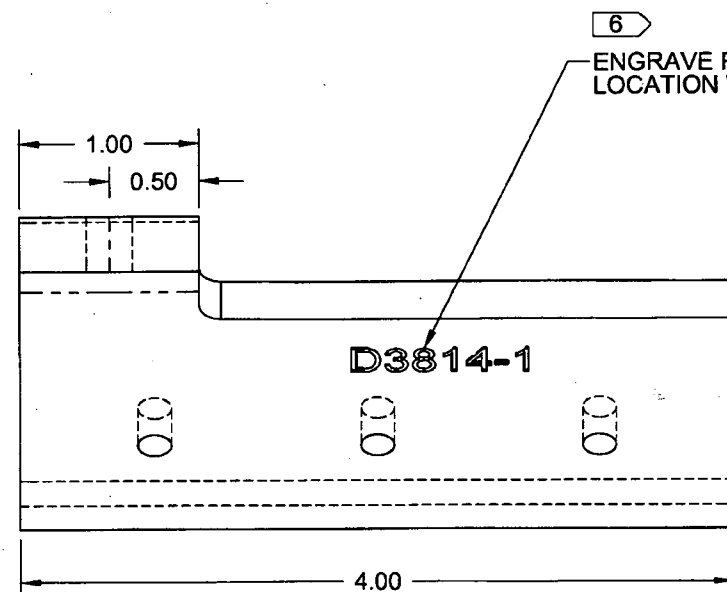
FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
3.30"	±.030"	3.304"	✓			
4.00"	±.030"	4.001"	✓			
.75"	±.030"	.749"	✓			
.13"	±.030"	.124"	✓			
R.13"	±.030"	R.125"	✓			
R0.250"	±.010"	R0.250"	✓			4 PL
1.50"	±.030"	1.500"	✓			
.13"	±.030"	.124"	✓			
* 1.30"	±.030"	1.301"	✓			
.20"	±.030"	.230"	✓			
.50"	±.030"	.500"	✓			
Ø.257"	+0.005" -0.003"	Ø.258"	✓			
R0.50"	±.030"	R.500"	✓			
1.00"	±.030"	1.001"	✓			
* 1.81"	±.030"	1.803"	✓			
1.05"	±.030"	1.050"	✓			
.21"	±.030"	.218"	✓			
1.00"	±.030"	.999"	✓			
.050"	±.030"	.050"	✓			
.75"	±.030"	.748"	✓			
.31"	±.030"	.310"	✓			
R.13"	±.030"	R.125"	✓			
.75"	±.030"	.747"	✓			

Measured by: JF.	Audited by: SP	Prototype Approval:	N/A
Date: 09/02/12	Date: 09/02/13	Date:	N/A

Rev	Date	Change	Revised by	Approved
A		New Issue	KJ/JLM	



D3814-1 HINGE, UPPER AIRFRAME

NOTES:

- 1) MATERIAL: 6061-T6 (OR 6061-T651/T6510/T6511/T62) BAR PER AMS-QQ-A-225/8 (OR AMS 4117/4128/4115/4116) PER AMS-QQ-A-200/8 (OR AMS 4160), (REF. DART SPEC. M6061T6B)
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1 POWDER COAT "WHITE GLOSS" (4.3.5.1) PER DART QSI 005 4.3
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.020 TO 0.030 MAX
- 6) IDENTIFICATION: ENGRAVE P/N AS SHOWN
- 7) WEIGHT: 0.36 lbs

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SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER NO. 45674

RELEASED
09/01/13

REV.	DESCRIPTION	BY	DATE
A	NEW ISSUE		08.11.10
DESIGN			
DRAWN			
CHECKED			
MFG. APPR.			
APPROVED			
DE APPR.			
DATE	08.11.10		

DART AEROSPACE LTD

HAWKESBURY, ONTARIO, CANADA

DRAWING NO.

D3814

REV. A

SHEET 1 OF 3

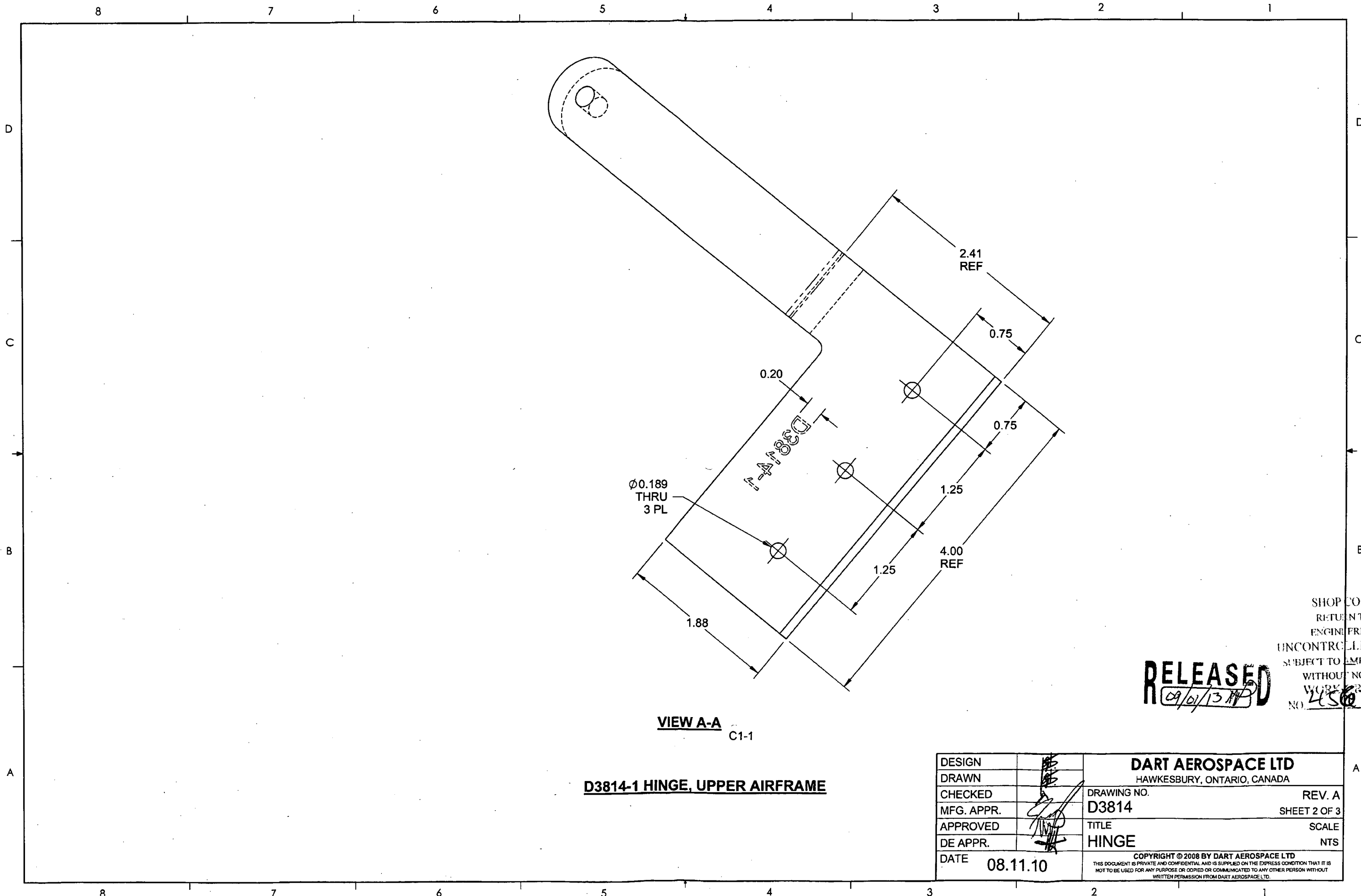
TITLE

HINGE

SCALE

NTS

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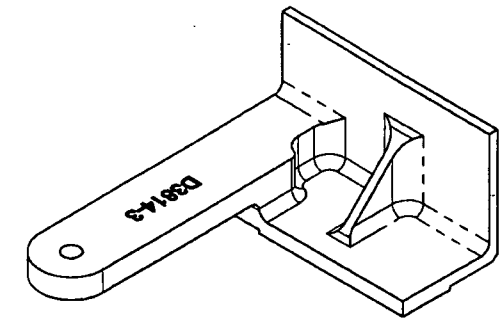
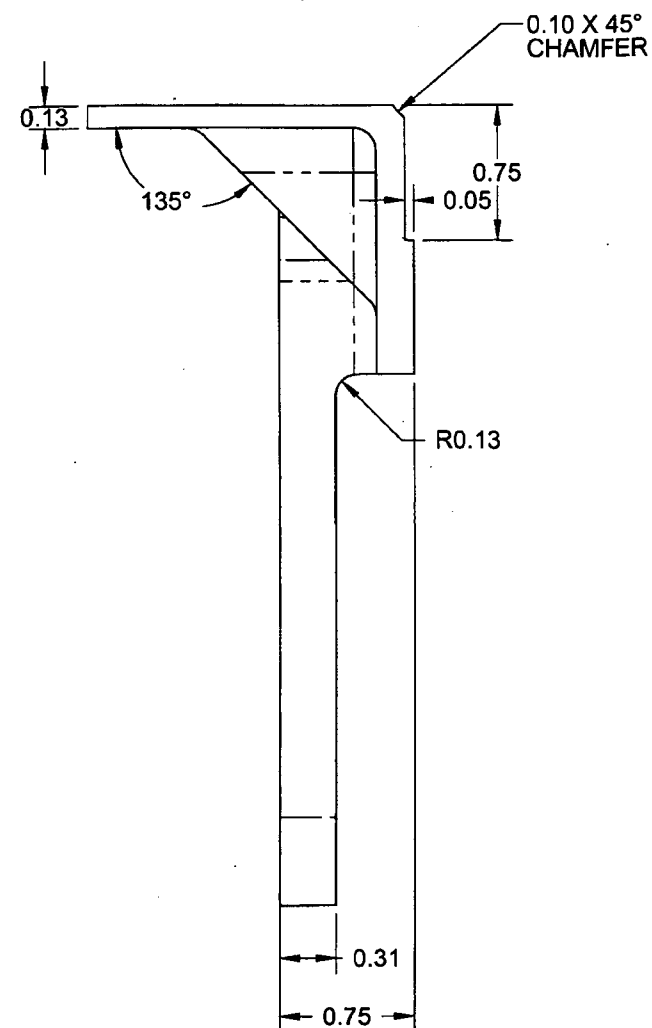
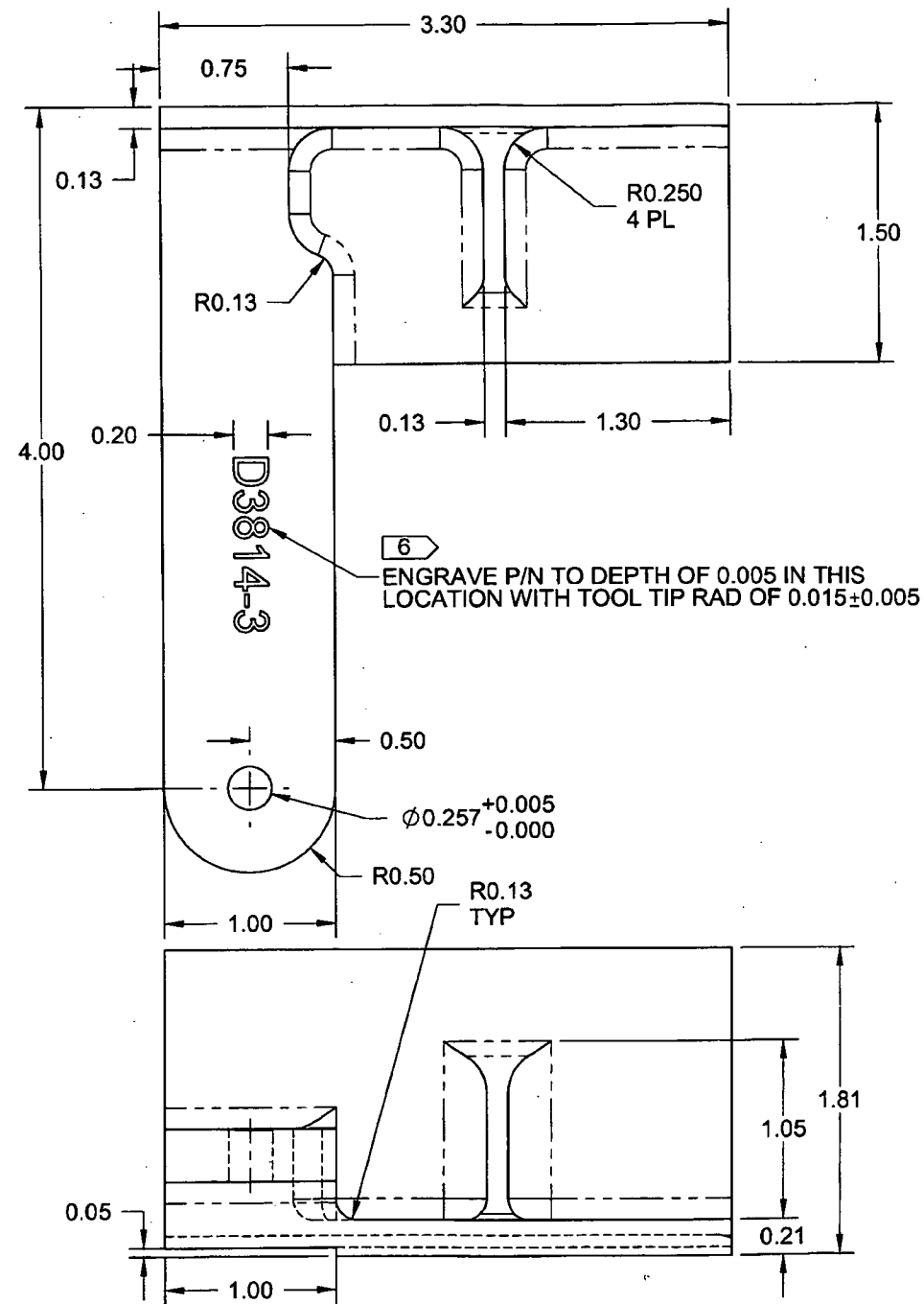
D3814-1 HINGE, UPPER AIRFRAME

VIEW A-A
C1-1

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D3814-3 HINGE, LOWER AIRFRAME

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09/01/13

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VENDOR
NO 45674

NOTES:

- 1) MATERIAL: 6061-T6 (OR 6061-T651/T6510/T6511/T62) BAR PER AMS-QQ-A-225/8 (OR AMS 4117/4128/4115/4116) PER AMS-QQ-A-200/8 (OR AMS 4160), (REF. DART SPEC. M6061T6B)
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT "WHITE GLOSS" (4.3.5.1) PER DART QSI 005 4.3
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.020 TO 0.030 MAX
- 6) IDENTIFICATION: ENGRAVE P/N AS SHOWN
- 7) WEIGHT: 0.31 lbs

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